

**Work Order ID 84902**

May-29-12 2:50:06 PM

**\*84902\***

Page 1

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/05/29

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D2906	Rev B	0.00							
-------	-------	------	--	--	--	--	--	--	--

100  
**\*100\***

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

003 per QCN12-599 W

N/A JH

110

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

0.00

- Inspect mat'l D2500-1-190 for damage

- Drill pilot holes using drill jig DT8149, DT8711-2 &amp; DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

→ CF 12-6-12

→ SAD 12-06-12

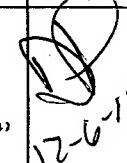
→ MG 12-6-12

WO: 84902

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-609-043 PAR #: \_\_\_\_\_ Fault Category: Extruded tube NCR: Yes  No  DQA:  Date: 12/07/18  
 Resolution: \_\_\_\_\_ Disposition: WAD - AS - is QA: N/C Closed:  Date: 12/7/18

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/18	140	Tubes are overbent. 2.350 Incl, 1.665 off.	GP 12/6/18	Acceptable TERM FWD END 0.1" - 0.125"	 12-6-18	GP 12/6/18	GP 12/6/18	S 12/6/18

NOTE: Date &amp; initial all entries

**Work Order ID 84902**

May-29-12 2:50:06 PM

**\*84902\***

Page 2

Item ID: D209-669-043

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\*****\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC3- Inspect Part Finish <i>QC</i>	0.00							<i>① SAD D-06-12</i>
Quality Control	Memo	0.00							

130

**\*130\***

Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *12409*Sikaflex expire date: *13-4-12*Start Time: *4:00* Date: *12/06/12*Fin Time: *11:00* Date: *12/07/12*

pick:

Qty P/N description

1 D2926-3 Web

B/N

*84950**QC 12/06/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
12-06-12	120	change Qc3 to Qc5					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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May-29-12 2:50:06 PM

**\*84902\***

Page 3

**Item ID:** D209-669-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\*****Revision ID:****Item Name:** Replacement Skidtube

Stop

**\*NS2\*****Start Date:** 29/05/2012 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 16/07/2012 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:**

Run Start

**\*NR1\*****QC:****Date:****SPC (Y/N):****Date:**

Stop

**\*NR2\*****Sequence ID/  
Work Center ID**

140

**\*140\***

CNC Bend 1

CNC Delta 100 Bender

**Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

0.00

BENDING MACHINE - CROSSTUBES

0.00

**Memo**

1-Bend as per program COB43FWD &amp; COBRAFT on CNC Bender and Folio FT

0.00

2-Cut tubes as per Dwg. D2906

150

**\*150\***

Skidtubes

Skidtubes

0.00

**Memo**

-Deburr ends and remove marks from bending

DE 12/06/05

- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

- DC 12/07/05  
B 12/07/05

160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

**Memo**

0.00

10 DE 12/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

170

**\*170\***

Skidtubes

Skidtubes

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Large Fab

Memo

0.00

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper  
not to hit web. Deburr

-Drill pilot holes for aft &amp; fwd cap using DT8215 open holes to #6" Deburr

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

①

SAD 2-0705

190

QC5- Inspect part completeness to step on W/O

0.00

5/26/105

**\*190\***

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 2:50:06 PM

\*84902\*

Page 5

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\*NS1\*

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Item Name: Replacement Skidtube

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\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Pressure Wash per QSI005 4.3

0.00

\*200\*

HandFinish

Hand Finishing

1 26 12-76

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*210\*

Powdercoat

Powder Coating

m12184

Memo

10:00 0.00  
START TIME: 320 01  
OVEN TEMPERATURE: 10:30

M.H  
12/6/06

220

QC3- Inspect Part Finish

0.00

\*220\*

QC

Quality Control

Memo

0.00

1 X 12/6/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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May-29-12 2:50:06 PM

**\*84902\***

Page 6

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Setup Start

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Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\*****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours**

## Tool ID

## Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

**\*230\***

HandFinish

Hand Finishing

HandFinishing

0.00

Memo 0.00

1-Install inserts &amp; wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 12/130Sikaflex expire date: 14/03

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd &amp; Aft Cap as per Dwg D2906 and seal Fwd &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 12/130Sikaflex expire date: 14/03

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: 1223201 8 (P) 12/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00 \*1\*

Required Date: 16/07/2012 Req'd Qty: 1.00 \*1\*

\*N900040100\*

Setup Start

\*NS1\*

Stop \*NS2\*

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID  
240

Operation  
Description  
QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours  
0.00

Tool ID Tool # Plan  
Code

Accept  
Qty  
Reject  
Qty  
Reject  
Number  
Insp.  
Stamp

\*240\*

QC

Quality Control

Memo  
0.00  
Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

\*250\*

Packaging

Packaging

Packaging

Memo  
0.00  
Identify and pack for shipping as per PPPD209-669-043  
Location: PPP Rev: PPP84883

260

\*260\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

12/17/18 D

12/17/18 D

MF  
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

## Picklist Print

May-29-12 2:50:10 PM

**Work Order ID:** 84902

**Parent Item:** D209-669-043

**Parent Item Name:** Replacement Skidtube

\*84902\*  
\*D209-669-043\*

Page 1

Start Date: 29/05/2012

Start Qty: 1.00

**Required Date:** 16/07/2012

**Required Qty:** 1.00

**Comments:** new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 2:50:10 PM

Page 2

Work Order ID: 84902

\*84902\*

\*D209-669-043\*

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

\*\*

4

(P)

12/07/09

\*AN3-5A\*

Bolt

Location	Loc Qty	Loc Code
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187✓	500	
121185	189	

AN960JD10L

NAS1149D0332✓ Purchased

No

230

Each

0.0000

4

4

\*\*

4

(P)

12/07/09

\*AN960JD10L\*

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

\*\*

44

(P)

12/07/09

\*ALS7-1032-130\*

Insert

Location	Loc Qty	Loc Code
ST280	121249✓	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 2:50:10 PM

Page 3

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Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

\*84902\*  
\*D209-669-043\*

Start Date: 29/05/2012

Start Qty: 1.00

Required Date: 16/07/2012

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

\*\*

44

(20)

12/07/09

\*AN3C4A\*

BOLT

AN960C10L

NAS1149C0332 Purchased

R

No

230

Each

0.0000

44

44

\*\*

44

(20)

12/07/09

\*AN960C10L\*

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

\*\*

14

(20)

12/07/09

\*D2594-3\*

O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP001

2418

\_\_\_\_\_

65518

41

\_\_\_\_\_

79496

984

\_\_\_\_\_

79573

50

\_\_\_\_\_

79755

1343

\_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 2:50:10 PM

Page 4

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\*D209-669-043\*

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

\*\*

14

(SP)

12/07/09

\*D2594-1\*

Plug, 205 Skidtube

Location	Loc Qty	Loc Code
FP001	98	

73401 30

74442 18

79495✓ 50

FP-A	213	
------	-----	--

73401 0

78590✓ 213

D3564-9

Manufactured No

230

Each

22.0000

1

1

\*\*

1

(SP)

12/07/09

\*D3564-9\*

Wearshoe

Location	Loc Qty	Loc Code
FG	84870✓	

76950 4

FP001	18	
-------	----	--

67590 4

69943 1

82255 13

D3564-11

Manufactured No

230

Each

8.0000

1

1

\*\*

1

(SP)

12/07/09

\*D3564-11\*

Wearshoe

Location	Loc Qty	Loc Code
FG	84871	

77056 4

FP001	4	
-------	---	--

80341 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 2:50:10 PM

Page 5

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\*D209-669-043\*

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Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Start Qty: 1.00

Required Date: 16/07/2012

Required Qty: 1.00

D3564-5

Manufactured No 230 Each 13.0000 1 1  
\*D3564-5\* 12/01/09

Wearshoe

Location	Loc Qty	Loc Code
FG 84869✓	2	
34806	2	
FP001	11	
77609	3	
82254	8	

D3566-1

Manufactured No 230 Each 31.0000 2 2  
\*D3566-1\* 12/01/09

Gasket

Location	Loc Qty	Loc Code
FP 84879✓	-22	
81619	10	
FP002	53	
68924	2	
80919	3	
83898	16	

D3566-5

Manufactured No 230 Each 21.0000 1 1  
\*D3566-5\* 12/01/09

Gasket

Location	Loc Qty	Loc Code
FP 84881✓	12	
82275	12	
FP002	9	
80374	3	
82274	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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WITHOUT NOTICE

WORK ORDER

NO. 84902 MLJ

12/05/29

QTY	QTY	Part Number	Description
-041	-043		
X	X	D2906-041	SKIDTUBE ASSEMBLY
		D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D257-9	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D285-5	AFT CAP
1	1	D2926-1	WEB
1	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	1	D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-15	GASKET
50	44	ALS7-1032-130	INSERT
		or AKS7-1032-130	
		or AKS4-1032-130	
		or ALS4-1032-130	
		AN3C4A	BOLT
50	44	AN3-5A	BOLT
4	4	AN960C10L	WASHER
50	44	AN960JD10L	WASHER
4	4		



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005.4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005.4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005.4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.04.04 *[Signature]*

B	UPDATE DRAWING FORMAT: RE-ORGANIZE: ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS;		
	PG 1: ADD NOTE 10;	CB	07.08.21
	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;		
	PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;		
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>7</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BY</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>CB</i>	D2906	SHEET 1 OF 3
APPROVED	<i>CB</i>	TITLE	SCALE
DE APPR.	<i>CB</i>	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21		

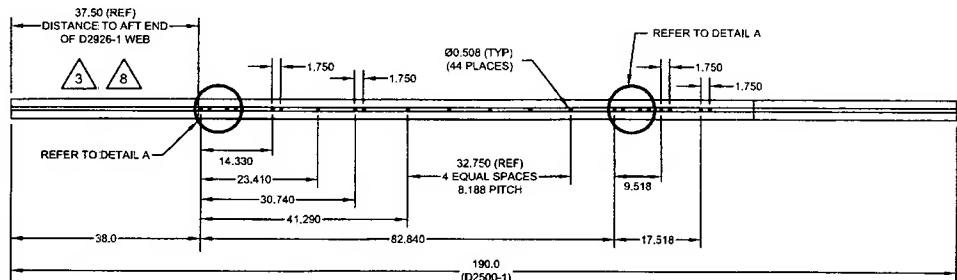
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

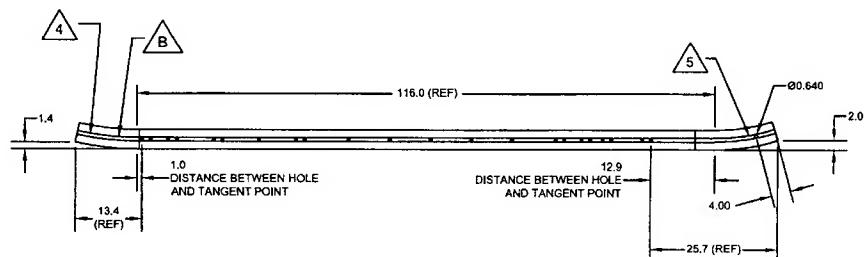
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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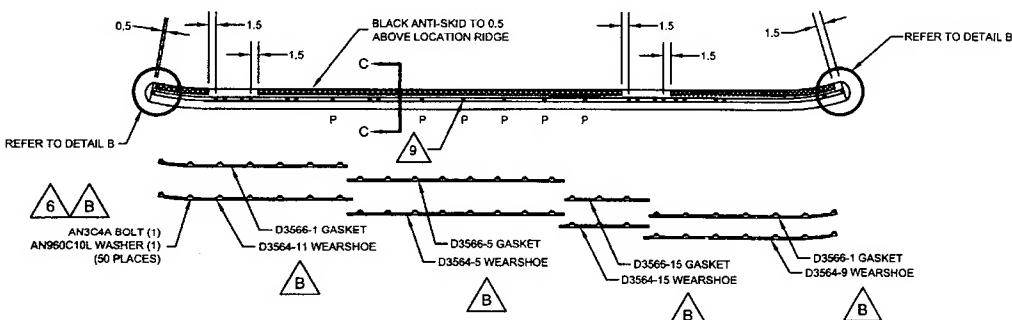
NOTE: Date & initial all entries



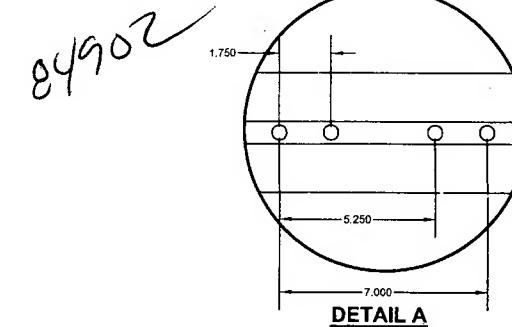
## D2906-1 DRILLING DETAIL



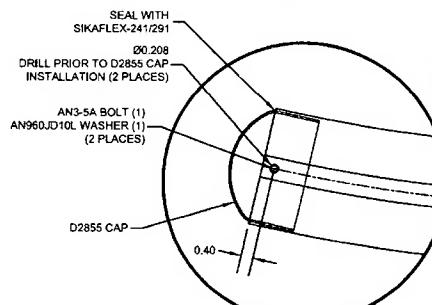
**D2906-041 BENDING AND CUTTING DETAIL**



**D2906-041 ASSEMBLY DETAIL**

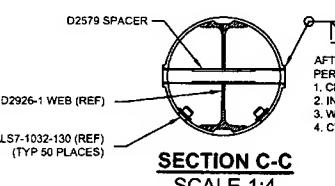


**DETAIL A**



**DETAIL B**  
SCALE 1:4

RELEASER  
07.09.04



**SECTION C-C**

DESIGN	99	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	91	D2906	SHEET 2 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	#	AH-1 (209) SKIDTUBE ASSEMBLY	
DATE	07.08.21	1:24	

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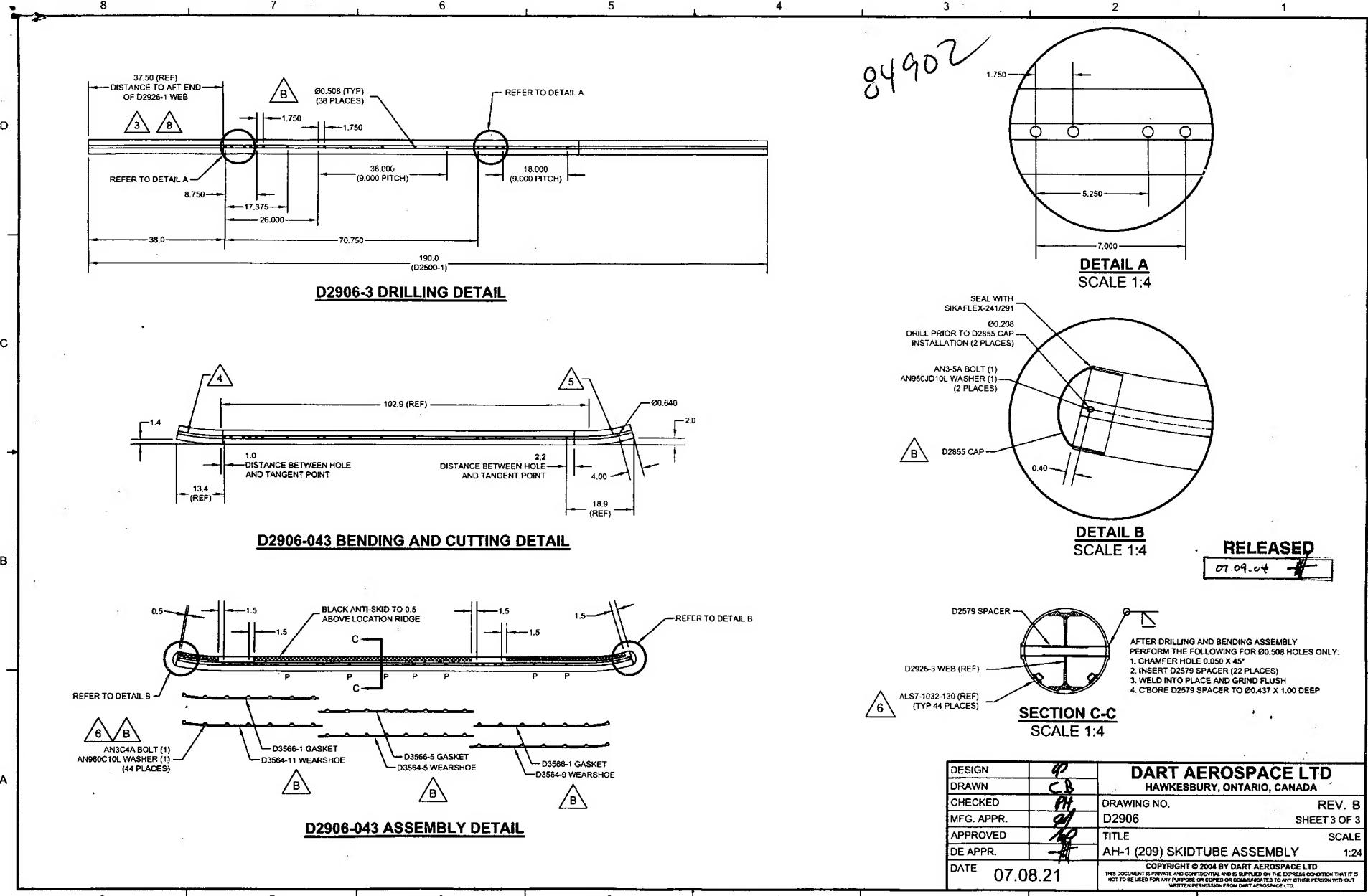
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